



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-C
Job Sheet 205450



Part No: C45-C

Job Qty: 1 pcs

Part Name: Single Cage Assembly (C45 & C60 Hook)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 2/24/20

Description: SIOP

Type: Stock

Note: C45-C rev.E IPP REV:A 18.01.22 NEW ISSUE DD VERF:DP IPP REV:B 19.05.02 AS PER DWG REV.E DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	External Load - Issue SN	1 pcs	2/24/20		0.00	1.00	External Load - 1		AP 2020-01-16
							External Load - 2		
							External Load - 3		
110	External Load - 2 - B4B	1 pcs	2/24/20		0.00	0.50	External Load - 1 - B4B		AP 2020-01-16
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	2/24/20		0.00	0.00	QC 5 - 10		DAS 58 JAN 16 2020 P-HQ
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
140	Packaging 3-1 - Stock - B4B	1 pcs	2/24/20		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S247979



Part: C45 - C

Job No: 205450

Serial No/Batch: S247979

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 01/16/20

				Packaging 3 - 6 - B4B	DAS 58 JAN 16 2020
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - FG	1 pcs	2/24/20	0.00 0.00	QC 21 - FG - 21	DAS 21 JAN 17 2020
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 100 - Issue S/N

Descriptions: **110** - (Small Fab) ASSEMBLE AS PER DWG ***HAND TIGHTEN ALL BOLTS, SPREAD COTTER PIN JUST ENOUGH SO THAT IT WILL NOT FALL OUT***

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: _____)

160 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN12H32	Bolt	1 pcs (1 ea)	100-External Load - Issue SN	5159804
AN310-12	Castellated Nut	1 pcs (1 ea)	110-External Load - 2 - B4B	5004855
AN8-23A	Bolt	2 Ea (2 ea)	110-External Load - 2 - B4B	5174259
C45-15-10	Ford Bumper	1 pcs (1 ea)	110-External Load - 2 - B4B	5199698
C45-15-11	Nut, Cage Bumper	1 Ea (1 ea)	110-External Load - 2 - B4B	5085248
C45-15-6	Bushing, Lifting	1 pcs (1 ea)	110-External Load - 2 - B4B	5180462
C45-15-7	Washer, Lifting Bolt	4 pcs (4 ea)	110-External Load - 2 - B4B	5175884
C45-18-7	Shim	4 Ea (4 ea)	110-External Load - 2 - B4B	5189687
C45-19C	Weldment	1 pcs (1 ea)	110-External Load - 2 - B4B	5239360
MS21044N8	Nut, Self-Lock .500-20, UNJF-3B	2 Ea (2 ea)	110-External Load - 2 - B4B	5200381
MS24665-363	Cotter Pin	1 Ea (1 ea)	110-External Load - 2 - B4B	5092509
NAS1149C0663R	Washer (AN960C616)	1 Ea (1 ea)	110-External Load - 2 - B4B	5076016-1
NAS1149F0832P	Washer (AN960-816L)	4 Ea (4 ea)	110-External Load - 2 - B4B	5076018

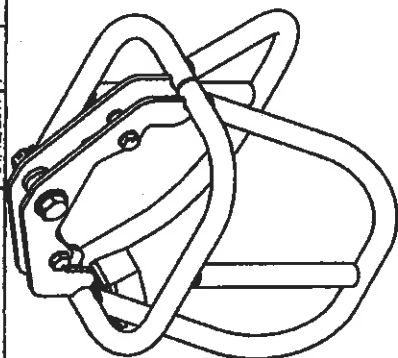
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-External Load - Issue SN	AN12H32	1	30	0
	AN310-12	1	10	0
110-External Load - 2 - B4B	AN8-23A	2	44	0
	C45-15-10	1	12	0
	C45-15-11	1	65	0
	C45-15-6	1	6	0
	C45-15-7	4	25	0
	C45-18-7	4	26	0
	C45-19C	1	1	0
	MS21044N8	2	14	0
	MS24665-363	1	31	0
	NAS1149C0663R	1	352	0
	NAS1149F0832P	4	121	0
Part Specifications				
Specifications could not be found.				

Plex 1/10/20 11:21 AM Dart.Renwick.Jennifer

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		AS DRAWN BY APICAL	11/6/2012	JAG	
4	15-0180	UPDATED TO NEW DRAFTING STANDARDS. CHD P/N WAS C45-15-9 IS AN960-816. C45-15-4 DELETED, REPLACED WITH AN8-23A. C45-15-5 DELETED, REPLACED WITH MS21044N8. C45-15-7 ADDED TO BOM QTY 4.	7/22/2015	DPD	JAG
E	19-660	Replace B/O info for C45-15-2, C45-15-3 and C45-15-12	04/12/2019	ML	ML



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WITHOUT NOTICE
WORK ORDER
NO. 205450

DART
AEROSPACE

C45 CAGE

DWG NO.	C45-C	REV	E
DRAWN BY:	APICAL	APPROVED	ML
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
XXX ± .005			
XX ± .01			
X ± .1			
1. BREAK ALL SHARP EDGES .015 ± .005			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	1:3	DATE	4/12/2019
SHEET	1 OF 1		

ASSY QTY	B/O	Part #	Description	Material	B/O INFORMATION OR SPECIFICATIONS
		C45-19C	WELDMENT		
		C45-15-2	LIFTING BOLT	STEEL	AN12H32
		C45-15-3	CASTLE NUT	STEEL	AN810-12
		C45-15-7	LIFTING BOLT WASHER	STEEL	3/4 (MCMASTER-CARR #98023A036)
		C45-15-9	COTTER PIN	SS	MS24665-363
		C45-15-10	FORD BUMPER		(#8312-4730-A) MODIFIED
		C45-15-11	CAGE BUMPER NUT	STEEL	M10, CLASS 8 (MCMASTER-CARR #90576A118)
		C45-15-12	CAGE BUMPER WASHER	STEEL	NAS1149C0603R
		C45-15-6	LIFTING BUSHING	4140/4142	
		C45-18-7	SHIM	STEEL	.025 X Ø.511 I.D. (MCMASTER-CARR #30884412)
		AN8-23A	BOLT	STEEL	1/2-20 X 1.47
		AN960-816	LIFTING BOLT WASHER	STEEL	AN960-816 (NAS1149F0843P)
		MS21044N8	NUT	STEEL	1/2-20